

# Work Order ID 54828

December 22, 2009 1:53:04 PM



Page 1

Item ID: D3166-1

Accept



Setup Start



Revision ID:

Item Name: Basket Hoop

Stop



Start Date: 1/05/10 Start Qty: 12.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: C2 Date: 09/12/23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3166    | Rev A1       |

100 Skidtubes 0.00



Skidtubes

Memo

0.00

Skidtubes

Cut 3/4" x 3/4" square tubing 60.00" long.

SAD  
09-12-30

12

110 BENDING MACHINE - SKIDTUBES 0.00



CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.

AA

(12x)

MS 10-01-04

120 QC6- Inspect dimensions to drawing 0.00



QC

Memo

0.00

Quality Control

Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)

2) 51060604

(12x)

M304TS075 Q65

63.15

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 54828**

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Item ID: D3166-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hoop

Start Date: 1/05/10 Start Qty: 12.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

10.01.05 (12)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.01.0510.01.05

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

December 30, 2009 9:00:54 AM

Page 1

Work Order ID: 54828

Parent Item: D3166-1

Parent Item Name: Basket Hoop

Comments:

Start Date: 1/05/10

Required Date: 1/15/10

Start Qty: 12.00

Required Qty: 12.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M304TS0.750W.065

Purchased

No

f

377.5900

63.1500



304 SQ Tube .75x.75x.065W

SAJ 09-12-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

377.5899742

113082

0.00419

113245

377.585784

63.15

Main Warehouse

WA

0.0000047

112398

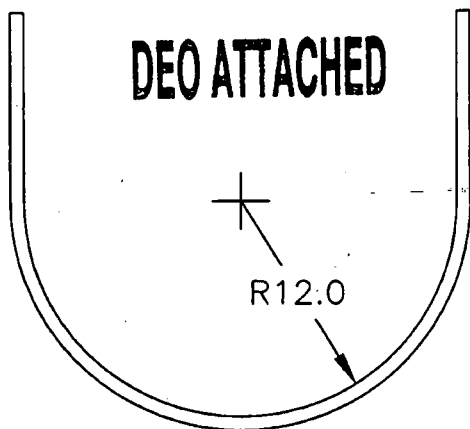
0.0000047



|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>#      | DRAWN BY<br>UP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D3166                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>02.07.10 |                | TITLE<br>BASKET HOOP                              | SCALE<br>NTS           |
| A                | 02.07.10       | NEW ISSUE   |                        |
| A1               | UP 04.04.08    | 38+/-1 was 36.0                                   |                        |

RELEASED  
02.08.06

DEO ATTACHED



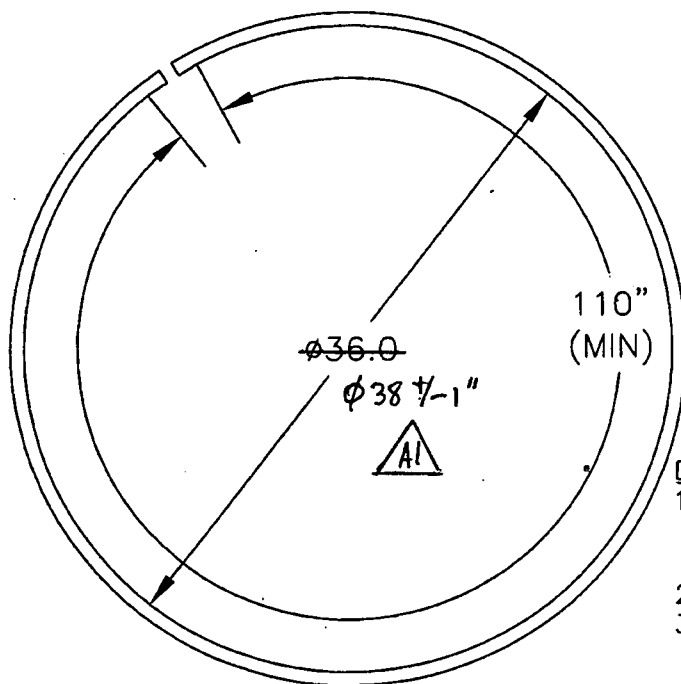
10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 54828

C209/12/23



D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

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|                      |                        |                           |   |  |                         |                     |              |
|----------------------|------------------------|---------------------------|---|--|-------------------------|---------------------|--------------|
| DRAWING NO.<br>D3166 | TITLE<br>BASKET HOOP   | REV A1                    | DART AEROSPACE LTD<br>ENGINEERING ORDER |  | D.E.O. NO.<br>D3166-A-2 | SHEET NO.<br>1 OF 1 | SCALE<br>NTS |
| DRAWN<br>AJS         | CHECKED<br>[Signature] | MFG. APPR.<br>[Signature] | APPROVED<br>[Signature]                 |  | DE APPR.<br>[Signature] |                     |              |
| DATE<br>08.12.11     | DATE<br>08.12.15       | DATE<br>08/12/15          | DATE<br>08/12/16                        |  | DATE<br>08.12.16        |                     |              |

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
60.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

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WORK ORDER  
NO. 54828

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
120.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

RELEASED  
08/12/16 [Signature]

REASON: SEE PAR 08-005